

Work Order ID 134209

Tuesday, July 07, 2015 10:48:30 AM

134209

Page 1

Item ID: D3368-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Start Qty: ~~2.00~~***2***

Cust Item ID:

Required Date: 7/17/15

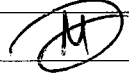
Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: Date: 15.7.7

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2690

B2

D3368

B

D3384

C

100

0.00

100

Small Fab

Small Fab

Memo

0.03

Small Fab

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371

3- Cut cable to length as per dwg D2690 and D3384

4- Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-047

Identify as D3371-53-Assemble lock mechanism and cam and install decal as per Dwg D3368.

1 FF OCT 22 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Tuesday, July 07, 2015 10:48:30 AM

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Page 2

Item ID: D3368-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tail Rotor Pedal Lock
Start Date: 7/07/15 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/17/15 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
110									
QC	Memo	0.00							
Quality Control									OCT 23 2015
120	Identify as per dwg & Stock Location: <u>St 49A</u>	0.00							DAS 6 9-89
120									
Packaging	Memo	0.00							1 OCT 26 2014
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							MCS OCT 26 2015
Quality Control									

SHA 20151026

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Work Order ID: 134209

134209

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/17/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028		Purchased	No			100	Each	87.0000	2	2			
										**		DAS 6	

238-028

3/16" Dowel Pin .5" long

Location	Loc Qty	Loc Code
ST568	87	
M132062	87	

385-039

Purchased

No

100

Each

84.0000

4

4

DAS

6
9-09

385-039

8-32 Flat screw

Location	Loc Qty	Loc Code
ST570	84	
M130688	84	

CBL-1240

Purchased

No

100

f

552.0772

2.3333

5

**

FF OCT 2 2 2015

CBI -1240

Cable

Location	Loc Qty	Loc Code
GA	552.0772	
M130006	52.0772	
m132518	500	

CBL-460

Purchased

No

100

Each

250.0000

2

2

**

FF OCT 2 2 2015

CBI -460

Loop Sleeve

Location	Loc Qty	Loc Code
GA	250	
m131619	250	

2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

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Work Order ID: 134209

134209

Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/17/15

Start Qty: 2.00

Required Qty: 2.00

D2728-7	Manufactured	No	100	Each	0.0000	0	0
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D2728-7

Dart Logo Label

D3368-1	Manufactured	No	100	Each	1.0000	1	1
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D3368-1

Pedal Lock Base

DAS
6
9-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST496

1

115046

1

D3368-3	Manufactured	No	100	Each	0.0000	1	1
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D3368-3

Pedal Lock Cover

133118

DAS
6
9-09

D3373-7	Manufactured	No	100	Each	13.0000	1	1
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D3373-7

Cam Lock

DAS
6
9-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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ST036

13

123528

2

94791

11

D3384-1	Manufactured	No	100	Each	7.0000	1	1
---------	--------------	----	-----	------	--------	---	---

D3384-1

Cyclic Sock

OCT 21 2014

DAS
6
9-09

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST500

7

123313

1

133088

6

DQA: _____ Date: _____



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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Parent Item: D3368-041

D3368-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 7/07/15

Required Date: 7/17/15

Start Qty: 2.00

Required Qty: 2.00

D3385-3

Manufactured No

100

Each

26.0000

1

made by hand

D3385-3

Hinge

m520257cy-7200
m129246

Location

Loc Qty

Loc Code

ST036

26

117534

26

HX-81

Purchased

No

100

Each

64.0000

1

HX-81

1/4"-20 SHCS 3/8" long

Location

Loc Qty

Loc Code

ST554

64

123436

64

NAS1149F0463P

Purchased

No

100

Each

1,248.000

2

NAS1149F0463P

Washer

Location

Loc Qty

Loc Code

ST260a

977

m127832

977

st268

271

m127832

247

m130388

24

DAS

6

9-89

OCT 21 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
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